

Date: Tuesday, 07/10/2008 10:16:31 AM  
 User: Julie Lecocq

## Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : LUG WELDMENT                          |
| <b>Job Number</b> : 42491                              |   |
| <b>Estimate Number</b> : 12116                         |   |
| <b>P.O. Number</b> :                                   | <b>Part Number</b> : D335313                                |
| <b>This Issue</b> : 07/10/2008 <b>S.O. No.</b> :       | <b>Drawing Number</b> : D3353 REV. A                        |
| <b>Prsht Rev.</b> : NC                                 | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY  | <b>Drawing Revision</b> : A                                 |
| <b>Previous Run</b> : 34676                            | <b>Material</b> :   |
| <b>Written By</b> :                                    | <b>Due Date</b> : 25/10/2008 <b>Qty:</b> 10 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JUL 08.10.07</u> |   |
| <b>Comment</b> : est rev A 06.01.26 new issue EC       |   |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation:        | Description :                       |
|---|------------------------------|-------------------------------------|
| 1.0   | M1018TR1250W109              | 1010-1025 Steel Tubing 1.250 x .109 |
|   |                              |                                     |
| <b>Comment:</b> Qty.: 0.9188 f(s)/Unit Total : 9.1875 f(s)<br>AISI 1018-1025 mild steel seamless round tubing<br>1.250" od X 0.109" wall batch: <u>M106091</u>      |                              |                                     |
| 2.0   | BAND SAW                     | BAND SAW                            |
|   |                              |                                     |
| <b>Comment:</b> BAND SAW<br>Cut blank 10.50" long as per dwg D3353 <div style="text-align: right;">SA 08/10/11 (10)</div>   |                              |                                     |
| 3.0   | MILLING CONV.                | CONVENTIONAL MILLING MACHINE        |
|   |                              |                                     |
| <b>Comment:</b> CONVENTIONAL MILLING MACHINE<br>1- Drill & tap as per dwg D3353<br>2-Deburr as per dwg D3353 <div style="text-align: right;">SA 08/10/11 (10)</div> |                              |                                     |
| 4.0   | INSPECT WORK TO CURRENT STEP | INSPECT WORK TO CURRENT STEP        |
|   |                              |                                     |
| <b>Comment:</b> INSPECT WORK TO CURRENT STEP <div style="text-align: right;">SA 08/10/11 (10)</div>   |                              |                                     |
| 5.0   | PACKAGING 1                  | PACKAGING RESOURCE #1               |
|   |                              |                                     |
| <b>Comment:</b> PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: <u>ST484</u> <div style="text-align: right;">SA 08/10/16 (10)</div>                        |                              |                                     |
| <div style="text-align: right;">4.1 QCB</div> <div style="text-align: right;">SA 08/10/15 (10)</div>  |                              |                                     |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 07/10/2008 10:16:31 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 42491

Part Number: D335313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

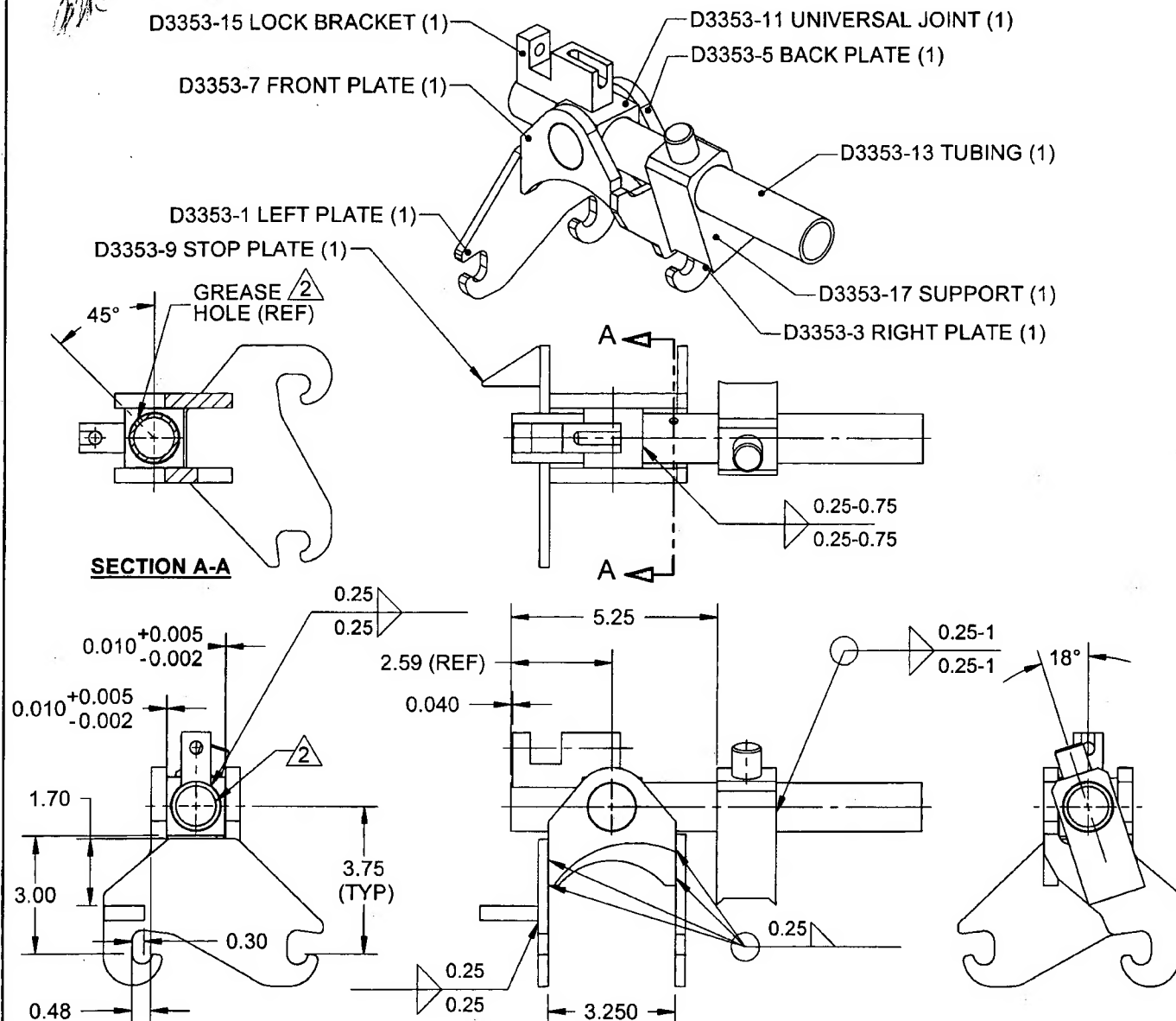
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|  |   |   |                         |
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| DATE<br>04.12.14   |   | TITLE<br>LUG WELDMENT                             | SCALE<br>1:4            |
| A  | 04.12.14  | NEW ISSUE   |                         |

RELEASED



## D3353-041 LUG WELDMENT

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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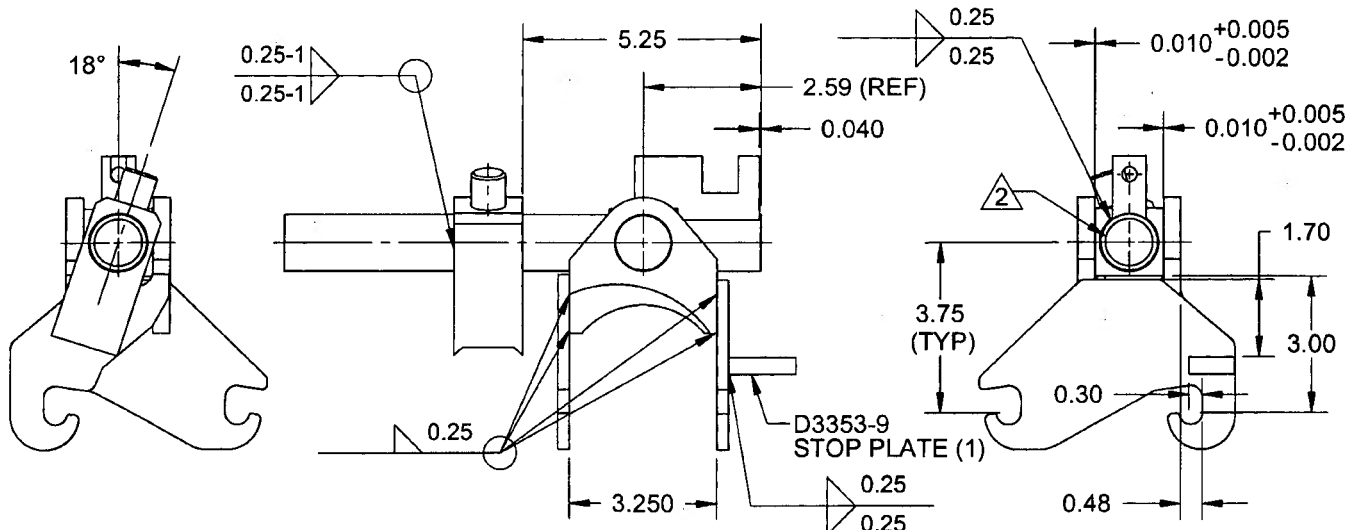
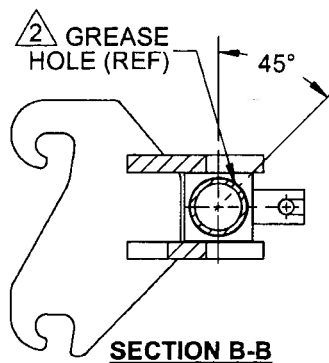
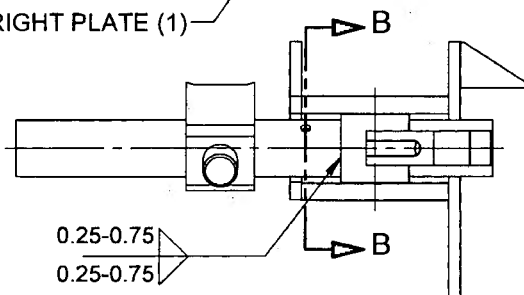
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| DATE<br>04.12.14       | TITLE<br>LUG WELDMENT   |   | SCALE<br>1:4            |

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D3353-11 UNIVERSAL JOINT (1)  
D3357-5 BACK PLATE (1)  
D3353-17 SUPPORT (1)  
D3353-13 TUBING (1)  
D3353-3 RIGHT PLATE (1)  
D3353-15 LOCK BRACKET (1)  
D3353-7 FRONT PLATE (1)  
D3353-1 LEFT PLATE (1)



### D3353-042 LUG WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

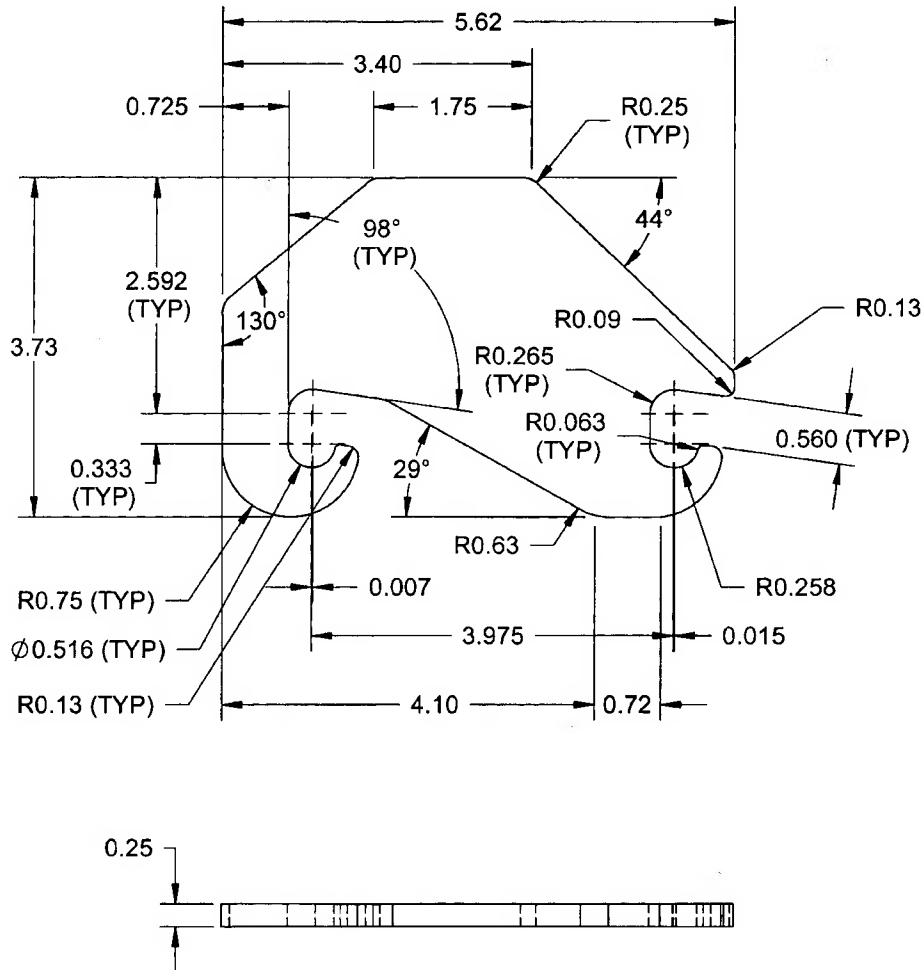
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| DATE<br><b>04.12.14</b>       |                                | TITLE<br><b>LUG WELDMENT</b>                             | SCALE<br>1:2            |

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*[Signature]*  
06/07/14**D3353-1 LEFT PLATE****NOTES:**

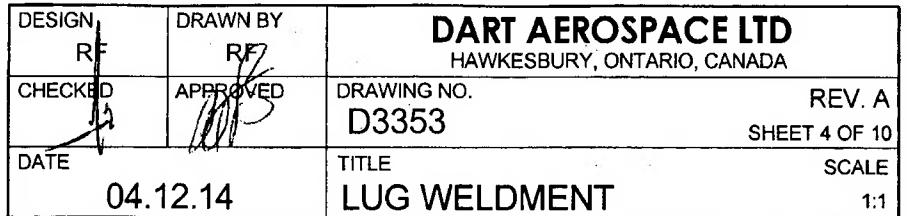
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK), SUBJECT TO AMENDMENT
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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[illegible]

└ 0.25

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2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

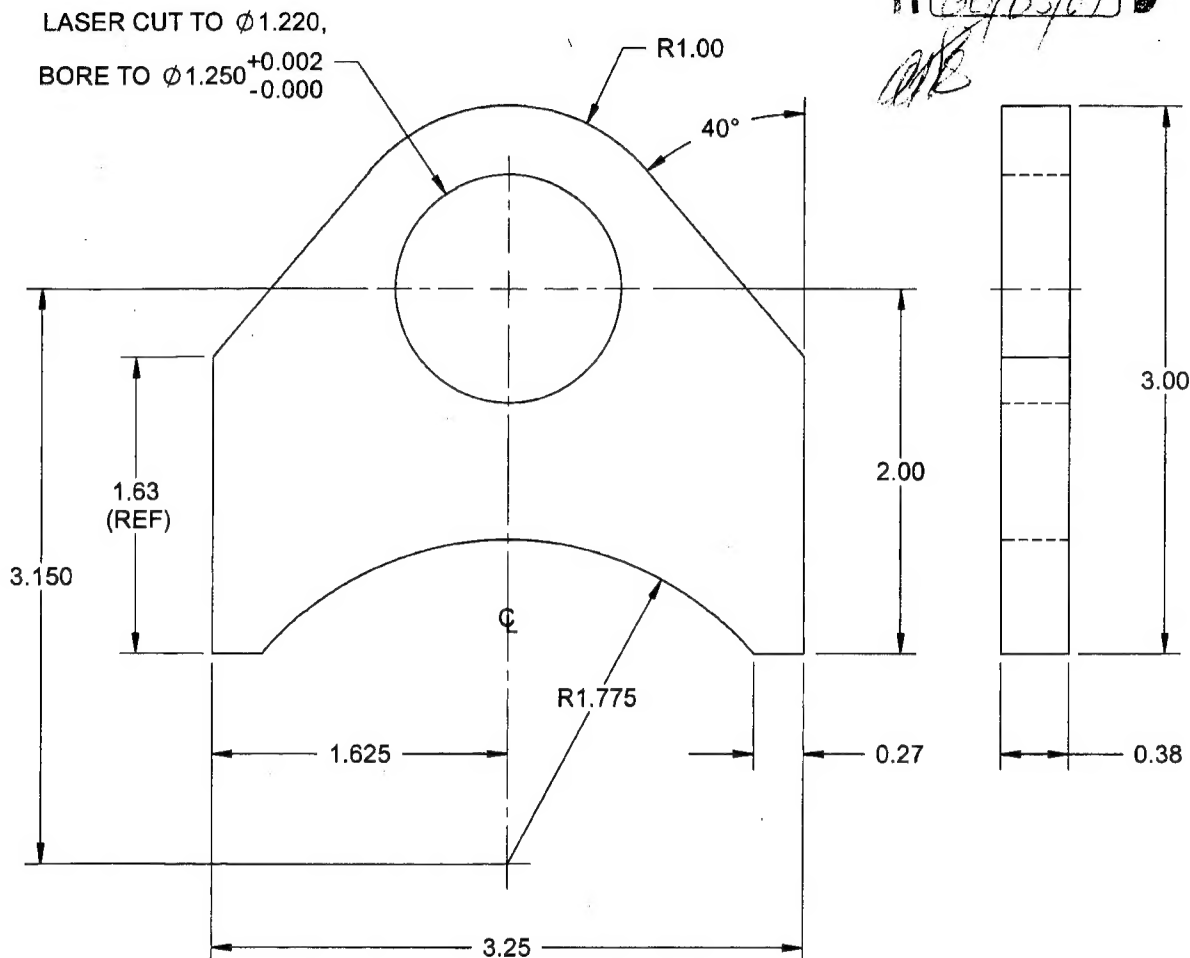
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| DATE<br><b>04.12.14</b>       | TITLE<br><b>LUG WELDMENT</b>   | SHEET 5 OF 10<br>SCALE<br>1:1                            |        |

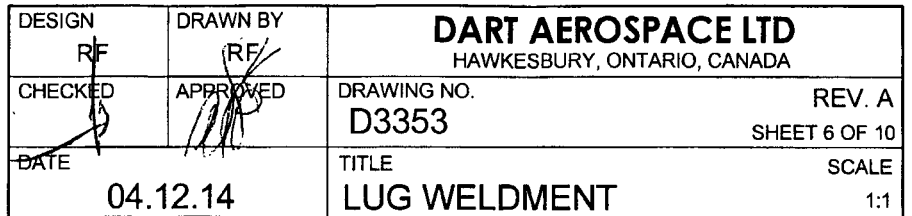
**D3353-5 BACK PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES  
STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

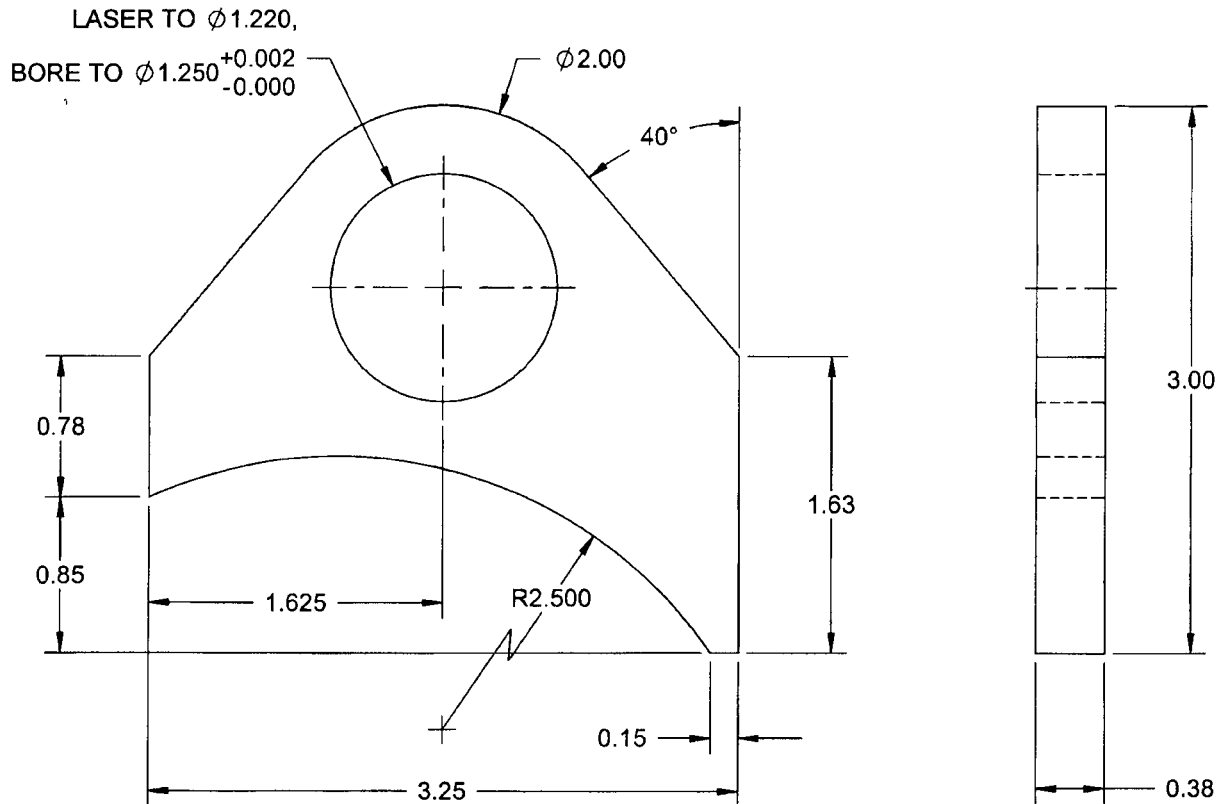
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**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR  
CSA G40.21, 38W/44W/50W/60W/70W SERIES  
STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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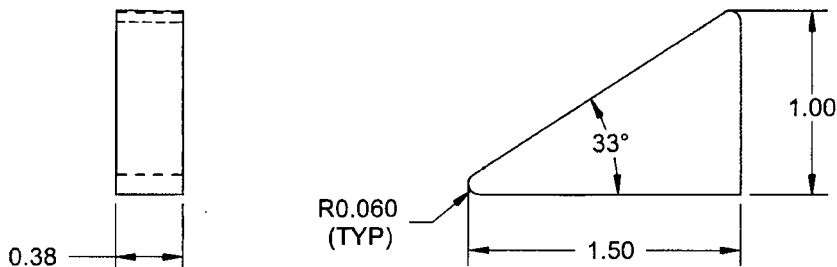
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| DATE<br><b>04.12.14</b> |                         | TITLE<br><b>LUG WELDMENT</b>                             | SCALE<br>1:1            |

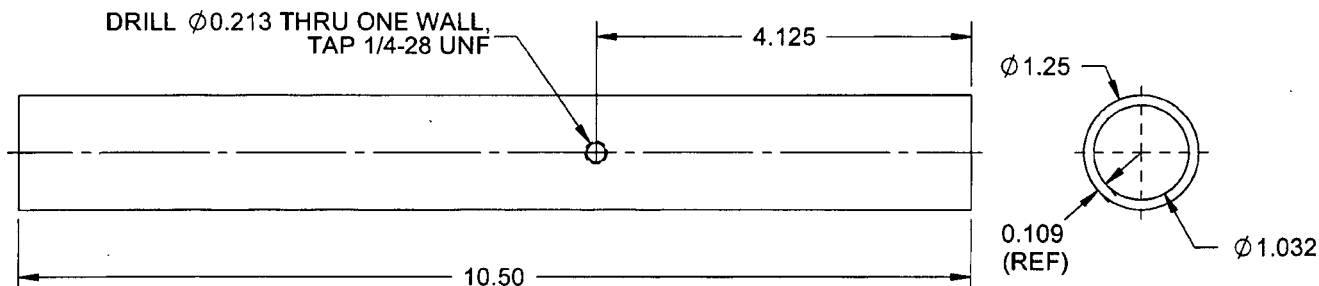
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[Signature]



### D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK  
MILD STEEL BAR (REF. DART SPEC. M1010-B)



### D3353-13 TUBING

#### NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,  
Ø 1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING  
(REF. DART SPEC. M1020TR1.250W.109)

#### NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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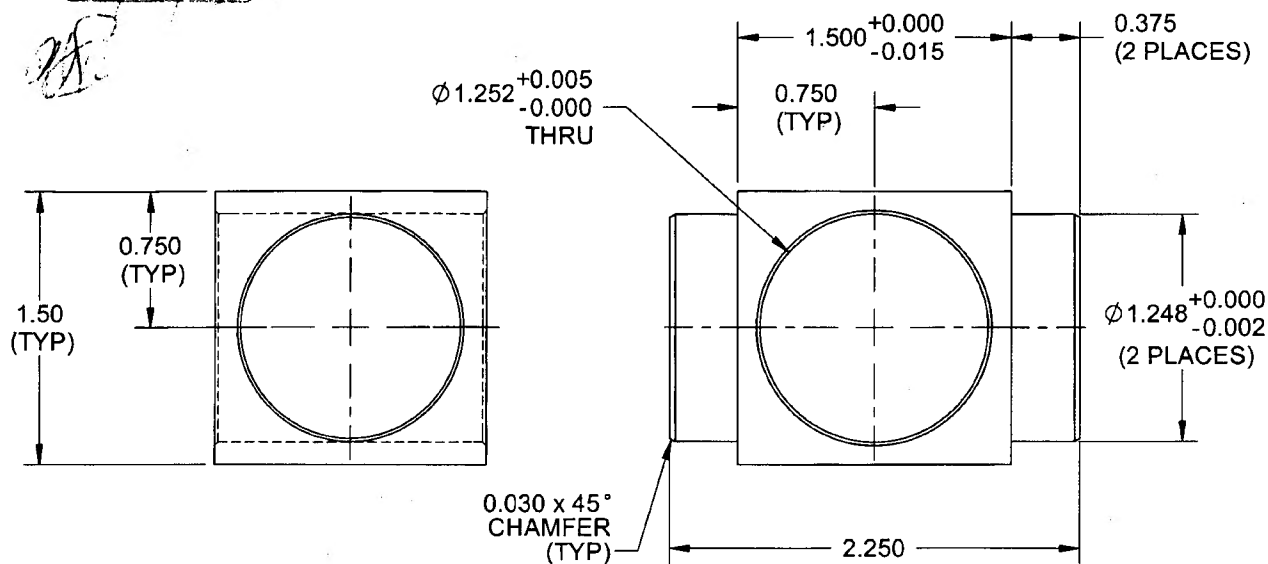
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| DATE<br>04.12.14 |                         | TITLE<br>LUG WELDMENT                             | SCALE<br>1:1            |

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06/03/09



### D3353-11 UNIVERSAL JOINT

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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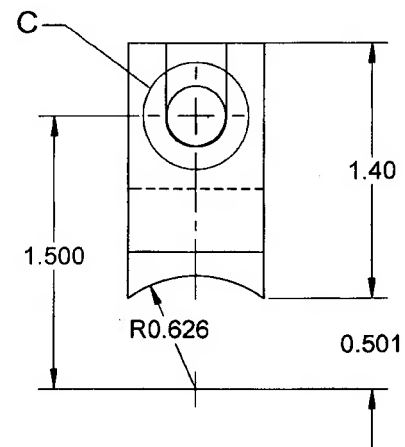
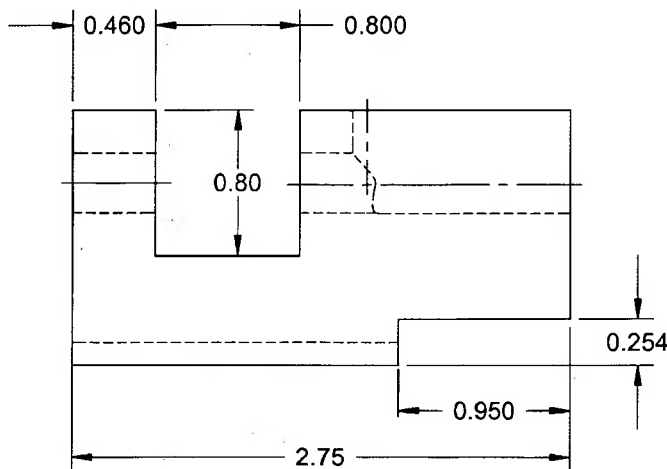
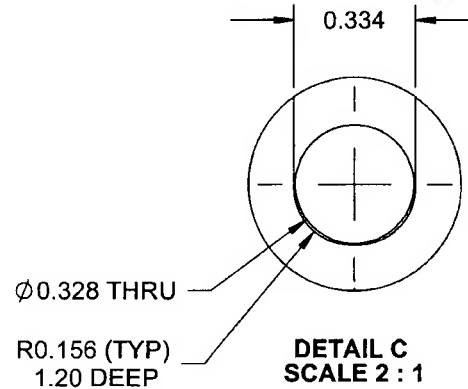
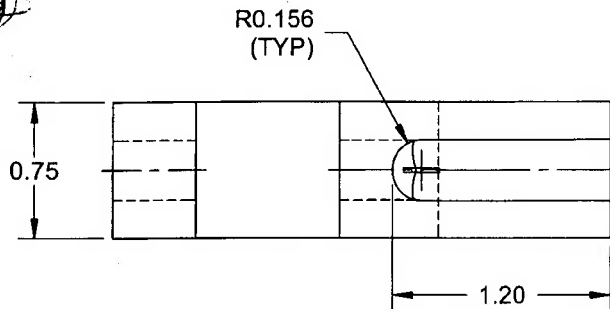
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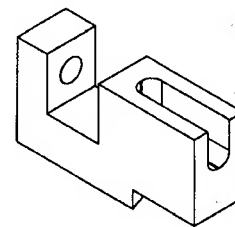
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| DATE<br><b>04.12.14</b> | TITLE<br><b>LUG WELDMENT</b> |  | SCALE<br>1:1            |

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06/02/09**D3353-15 LOCK BRACKET****NOTES:**

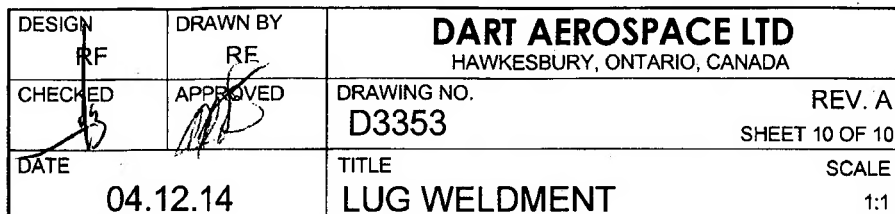
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
**SCALE 1:2**

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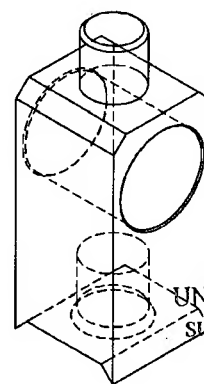


1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD  
STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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